

Date: Monday, 08/06/2009 1:12:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 48413	
Estimate Number : 10198	
P.O. Number :	Part Number : D21752
This Issue : 08/06/2009 S.O. No. :	Drawing Number : D2175 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 35342	Material :
Written By :	Due Date : 15/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.06.08</u>	
Comment : Est E 04.06.09 Reformat KJ/RF	
Est Rev:F 06-04-28 Manufactured on Water Jet JLM	
Est Rev:G As per Rev E 06-11-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 111787 B96-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2175

Dwg Rev: E

Prog Rev: E

B96-9

(14)

2-Deburr if necessary

B96-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/06/10

(14)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ANGLE

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Part Number: D21752

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 09/06/10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-11 (13)



8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-06-11

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 09/06/11

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SA 09/06/11

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF
09-06-11



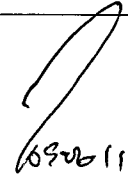
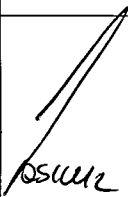
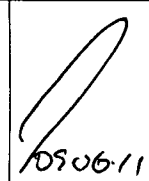
Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090611	7.0	1 part scrap. Fuel blowouts around a hole. RC: process		Scrap: destroy & no replace.	 09/06/11	 090611	 090611	 090611

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48413
Description: Angle		Part Number: D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	X			
R0.35	+/-0.030	.135	X			
2.915	+/-0.010	2.920	X			
50°	+/-0.5°	50°	X			
0.300	+/-0.010	.301	X			
1.050 Pitch	+/-0.010	1.050	X			
10.500	+/-0.010	10.505	X			
11.550	+/-0.010	11.553	X			
0.550	+/-0.010	.550	X			
0.900	+/-0.010	.899	X			
0.063 thick	+/-0.010	.065	X			
Grain Direction	N/A	Yes	X			
Ø0.128	+0.005/-0.001	.131	X			
Ø0.172	+0.005/-0.001	.176	X			

Measured by: RB
Date: 9-6-9

Audited by: S
Date: 07/06/10

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

